

Date: Monday, 09/03/2009 1:41:58 PM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : SPACER BUSHING

Job Number : 46325

Estimate Number : 10823

P.O. Number :

Part Number : D23271

This Issue : 09/03/2009 S.O. No. :

Drawing Number : D2327 REV D

Prsht Rev. : NC

Project Number : N/A

First Issue : / / Type : MACHINED PARTS

Drawing Revision : D

Previous Run : 40390

Material :

Due Date : 20/03/2009

Qty:

out of material
46
50 Um: Each

Written By :

Checked & Approved By :

JUD 09.03.09

Comment :

Est. D 05.11.02 Removed 303 SS KJ/EC

Est Rev:E Removed 303SS JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304R0375

304 ROUND BAR 0.375



Comment: Qty.: 0.1860 f(s)/Unit Total : 9.2978 f(s)
Inventory

Material: AISI 304 Round Bar Ø0.375"
(M304R0.375)

Batch:

M110472

SA 09/03/10

* no more material
8.2 Pt

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

Turn per Folio FA232 and Dwg D2327
Deburr

SA 09/03/10

(46)

out of material

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 09/03/10

(46)

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 09/03/10

(46)

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location:

STEVE Basket Cell

SA 09/03/11 (46)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER BUSHING

Job Number: 46325

Part Number: D23271

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/11 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-03-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

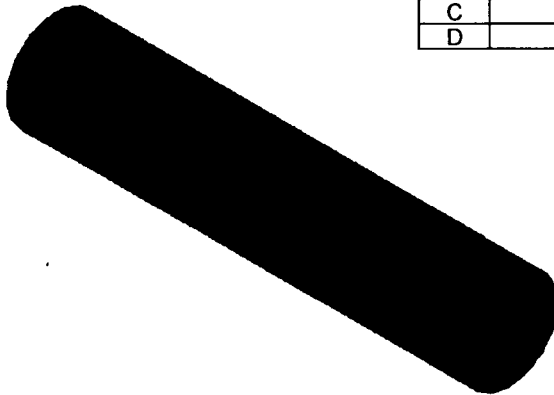
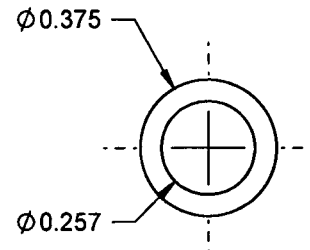
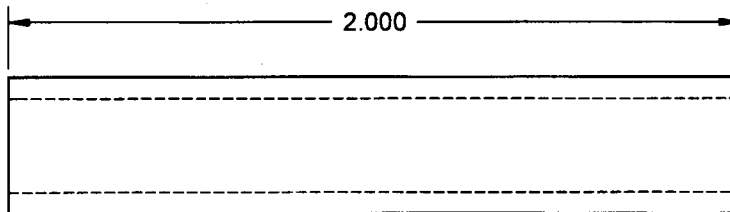
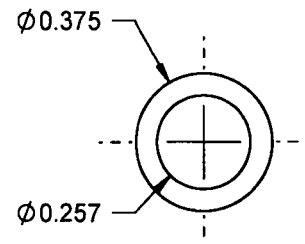
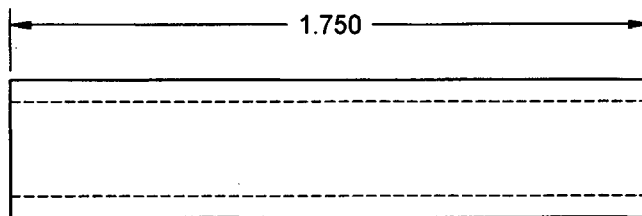
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED CH	DRAWING NO. D2327	REV. D SHEET 1 OF 1
DATE 06.10.12		TITLE SPACER BUSHING	SCALE 2:1
REV	DATE	DESCRIPTION	
A	94.12.17	NEW ISSUE	
B	95.12.06	LENGTH CHANGE	
C	03.05.13	303 SS SPEC ADDED	
D	06.10.12	REMOVE 303 SS MATERIAL	

**RELEASED**06.11.14 **TH****D2327-1 SPACER BUSHING****D2327-3 SPACER BUSHING****NOTES:**

- 1) MATERIAL: AISI 304/316 SS, $\phi 0.375$, 0.065 WALL SEAMLESS ROUND TUBING (REF. DART SPEC M304TR0.375W.065)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX

SHOP COPY
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WORK ORDER
NO. **40325**

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